

Work Order ID 165777***165777***

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Monday, August 28, 2017 2:22:17 PM

Item ID: D412-769-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Facing Seat, RH

Start Date: 8/28/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-769	Rev C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-769-042	CHG 002							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.03							
Quality Control									

DAS
28
9-89

SEP 06 2017

AUG 29 2017

DAS
6
9-89
DAS
27
9-89DAS
28
9-89

SEP 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐						

Work Order ID 165777***165777***

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Monday, August 28, 2017 2:22:17 PM

Item ID: D412-769-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Facing Seat, RH
Start Date: 8/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/6/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo Identify and pack for shipping as per PPP D412-769-042 Location: _____ PPP Rev: _____	0.00 0.00 PPP165765						SEP 06 2017 DAS 28 9-89	
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							17/9/11 SEP 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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165777

D412-769-042

Required Date: 9/6/2017

Required Qty: 1.00

Comments: IPP rev A 08-07-17 new issue DD verified by:EC IPP Rev:B
10.03.23 as per IIN revC DD verified by:EC IPP Rev:C 10.06.07
added pick kit DD verf:EC IPP REV:D 12.07.27 @ CHG002
(ECN12-621) DD VEF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-724-041		Manufactured	No			105	Each	2.0000	1	1			
D412-724-041 Head Rest Assembly, Center													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG017		2							
				162020		2							
D412-724-044		Manufactured	No			105	Each	0.0000	1	1			
D412-724-044 Head Rest Assembly, RH													
D412-769-044		Manufactured	No			105	Each	0.0000	1	1			
D412-769-044 Aft Facing Seat Assembly, RH													

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH